

**Work Order ID 66019**

Tuesday, February 01, 2011 3:52:09 PM



Page 1

Item ID: D3550-1

Revision ID:

Item Name: Strut

Start Date: 2/1/2011 Start Qty: 12.00

Required Date: 2/7/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: *PL*Date: *11/02/11*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3550

Rev B

100



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form per Dwg D3550 using DT 8012

*=> M-L 11/02/09*

110



Small Fab

0.00

Small Fab

Memo

Small Fab

1-form other end of strut at 1.8" using DT 8984 2-Deburr if necessary.

*(12X)**=> M-L 11/02/09*

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

*11 02 09 (12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66019**

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Item ID: D3550-1

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 2/1/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

m 115951

Memo

11:50

0.00

12.

BL 11-2-10

START TIME:

1000

FINISH TIME:

1200

OVEN TEMPERATURE:

1200

12:00

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

12

BL 11-02-10

Memo

0.00

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 271

0.00

Memo

0.00

Patterson 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66019**

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Page 3

Item ID: D3550-1

Revision ID:

Item Name: Strut

Start Date: 2/1/2011 Start Qty: 12.00

Accept



Setup

Start



Stop



Required Date: 2/7/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Memo

11/02/14  
MF

11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 66019



Parent Item: D3550-1



Parent Item Name: Strut

Start Date: 2/1/2011

Required Date: 2/7/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 07.02.05 New iwssue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			110	f	176.5977	1.7	21.47368			

304 RD Tube .500 x .049W



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	172.7647378	
114676	11.9789478	
115010	160.78579	
MAT017	3.833	
111814	3.833	

*MJ 11/02/09*

*21-47368*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

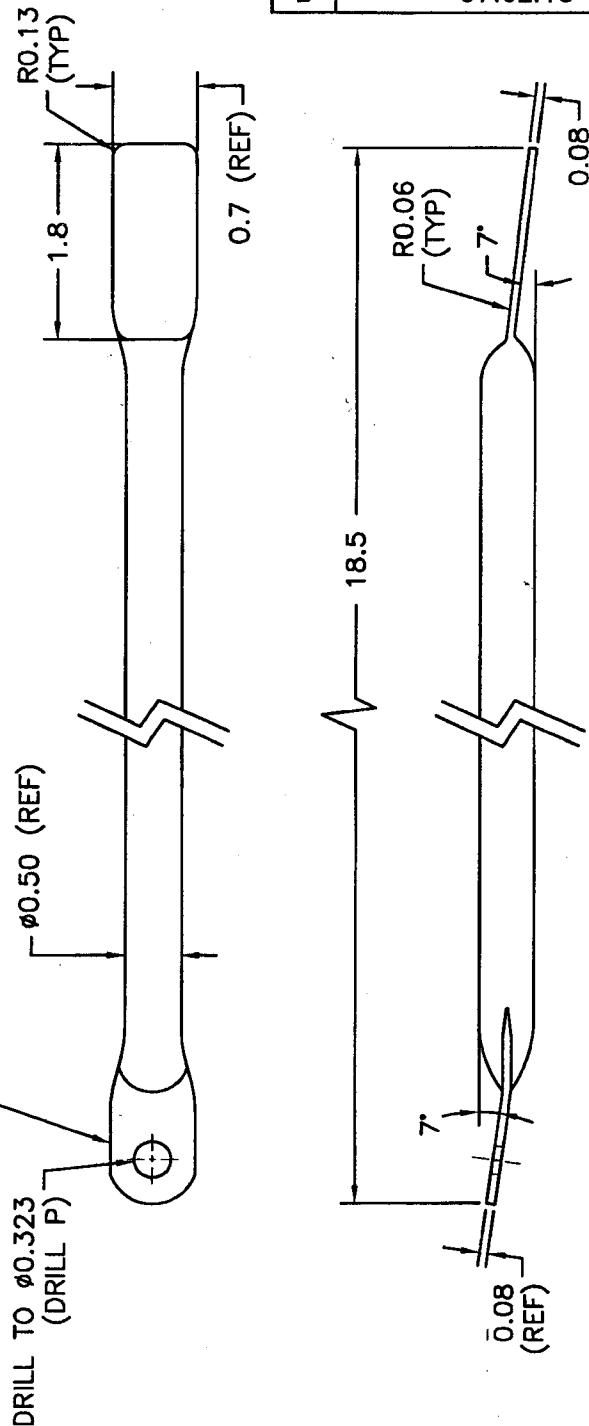
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	<i>[Signature]</i>	D3550	SHEET 1 OF 1
DATE		TITLE	SCALE
07.02.13		STRUT	NTS
A	06.10.24	NEW ISSUE	
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5	



**RELEASED**  
07-02-27 *[Signature]*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *06019*

**D3550-1 STRUT**

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL (REF DART SPEC M304 TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.35.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

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